

Date: Monday, 24/11/2008 9:54:33 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.

Drawing Name : D058-676-101

Job Number : 43714

Estimate Number : 10804

P.O. Number :

Part Number : D058676101

This Issue : 24/11/2008 S.O. No. :

Drawing Number : ECN08-563

Prsht Rev. : NC

Project Number :

First Issue : // Type : CROSSTUBES

Drawing Revision :

Previous Run : 00015

Material :

Due Date : 01/12/2008 Qty: 1 Um: Each

Written By : Checked & Approved By : 

Comment :

Additional Product

Job Number:



<b>DART</b>			
TRANSPORT CANADA APPROVAL #09-89			
PN	D058-676-101	CHG	CHG001
DESC	Crosstube Fwd High	SIC	SR01018SE
LOT	B35532	SIC	
MODEL	OH- 58A+/A/C	SIC	
MADE IN CANADA			

Seq. #: Machine Or Operation:

Description :

1.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: CROSSTUBES RESOURCE 1

Magna bond B#: 108966  
 exp: 10/2009

REMOVE FROM STOCK:

1 X D058-676-101 B35532 CHG001

REMOVE SUPPORTS D2891-1

RE-INSTALL PER ECN 08-563

PER DSI 9425, WITH MAGNABOND

REMOVE D2856-400-694 AND REPLACE  
 WITH D3595-063-395 B 42998

ml 08.11.25 (1)

2.0

D058676101

Crosstube Fwd



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Crosstube Fwd

ml 08.11.25 (1)

3.0

D3595

Rubber Cushion (per sq ft)



Comment: Qty.: 1.0000 sf(s)/Unit Total : 1.0000 sf(s)

Rubber Cushion (per sq ft)

ml 08.11.25

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.11.26 (1)

Date: Monday, 24/11/2008 9:54:33 AM  
User: Linda Lacelle

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D058-676-101

Job Number: 43714

Part Number: D058676101

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Labels checked *SS*

REPACKAGE USING NEW B/N @ CHG002  
NEW LABELS AND PAPERWORK REQ'D

*Per C 8/11/27*

*SP*

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/12/01*

Job Completion



*mf 08-11-28*

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D058-676 REV. A AND  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D058-676 REV. 0  
REF: FAA STC: SR01018SE

For D058-676-101/-201 crosstubes at CHG 002 or later, the D2856-400-694 abrasion strips have been removed, the D2891-1 supports have been bonded onto the crosstube using Magnabond 6398 and D3595-063-395 Rubber Cushions have been installed underneath the MS21920-20 Clamps. Amend parts list of the IIN-D058-676 Section 5 and ICA-D058-676 Section 32.8 as follows:

## REMOVE:

ITEM	QTY -101	QTY -201	PART NUMBER	DESCRIPTION
11	2	2	D2856-400-694	ABRASION STRIP


## ADD:

ITEM	QTY -101	QTY -201	PART NUMBER	DESCRIPTION
16	4	4	D3595-063-395	RUBBER CUSHION

To prevent the supports from shifting on the D058-676-101/-201 crosstubes at CHG 001, the D2891-1 supports should be removed and re-installed as follows:

- 1) Follow section 32.1 of ICA-D058-676 for the removal of the crosstubes from the helicopter.
- 2) Remove the qty (2) MS21920-20 clamps from the crosstube that fasten each D2891-1 support to the crosstube.
- 3) Remove the D2856-400-694 abrasion strips from the crosstube per section 32.5 of ICA-D058-676.
- 4) Inspect the crosstube surface underneath each support for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection of ICA-D058-676. Repair damage within acceptable limits per item 5.3.3 of the 300 hour inspection in ICA-D058-676. Touch up finish per item 5.3.9 of the 300 hour inspection.
- 5) Abrade area to which support will be applied with 400 grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe area until there is no residue.
- 6) Apply a 0.03" to 0.06" thick layer of Magnabond 6398 underneath each D2891-1 support and re-install the support on the crosstube as shown in Figure 1. Position and secure the D2891-1 supports on the crosstube using MS21920-20 Clamps. Install a D3595-063-395 Rubber cushion underneath each MS21920-20 Clamp. Torque clamps 80-100 in-lb. Let the D058-676-101/-201 crosstube assembly cure as per the Magnabond 6398 instructions before re-installing the crosstube on the aircraft.

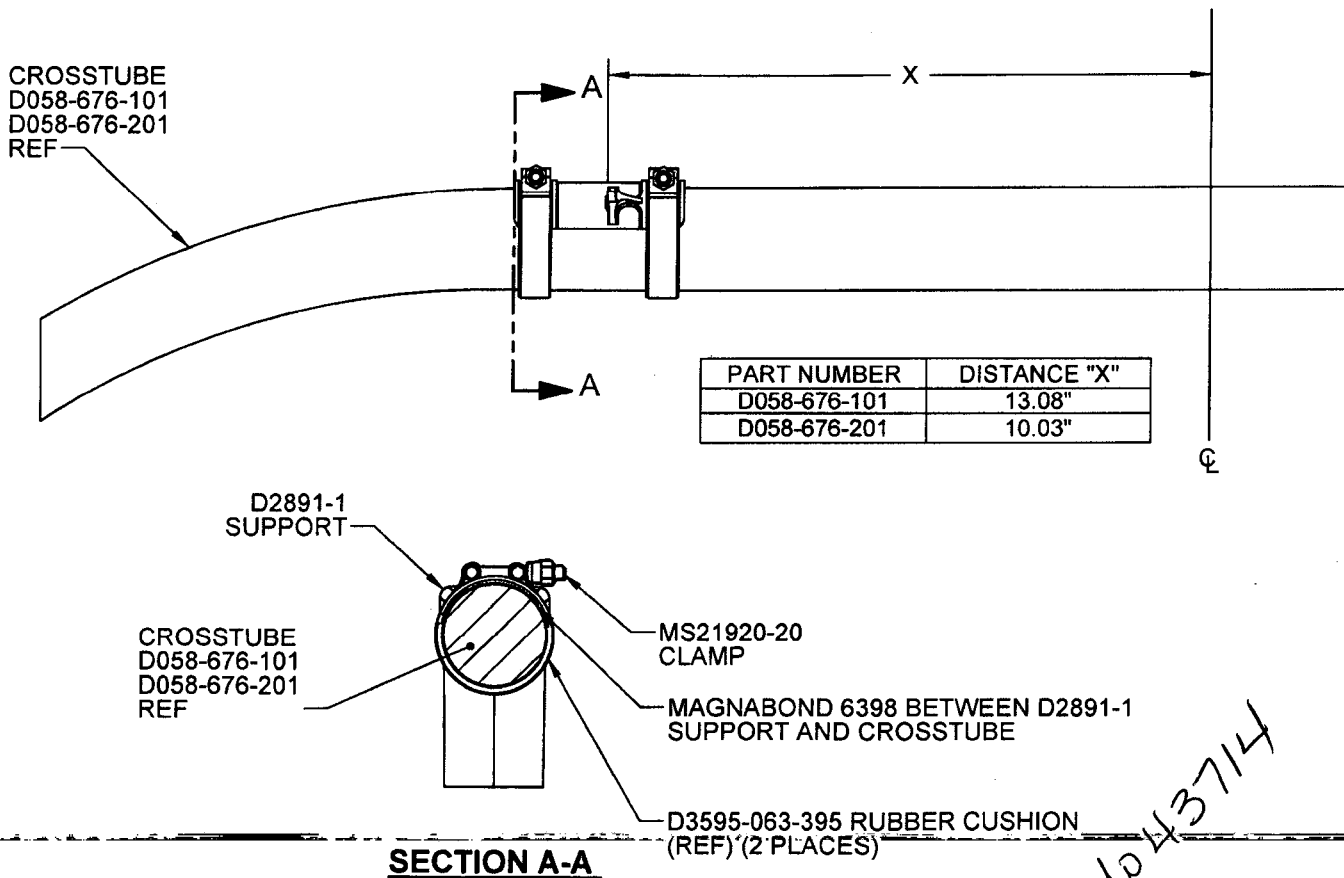
WLO 43714

A	NEW ISSUE	RF	08.11.06
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	DS	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9425	SHEET 1 OF 2
APPROVED	DS	TITLE	SCALE
DE APPR.		CROSSTUBE SUPPORT CHANGE	NTS
DATE	08.11.06	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

7) Re-install the D058-676-101/-201 crosstube per section 32.2 of ICA-D058-676.

For customers who would like to upgrade their D058-676-101/-201 crosstubes from CHG 001 or earlier to CHG 002, the following kit can be obtained from Dart:

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9425-011	CROSSTUBE SUPPORT CHANGE (USABLE ON D058-676-101/-201)
4	D3595-063-395	RUBBER CUSHION



**FIGURE 1 - CROSSTUBE SUPPORT**

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	DS	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9425	SHEET 2 OF 2
APPROVED	DS	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CROSSTUBE SUPPORT CHANGE	NTS
DATE	08.11.06	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

# ENGINEERING CHANGE NOTICE

## DART AEROSPACE LTD

Date: 08.11.11	Job No.:	ADR Yes/No: Y	ADR Date: 08.11.11	ECN #: 08- 563
Product No.: D058-676		Created By: <i>[Signature]</i>	Approved By: <i>[Signature]</i>	
Product Name: Crosstubes		Checked By: <i>[Signature]</i>	General Manager Approval:	

Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL	
Production Engineering Coord	Y	DD/EC	
Production Document Control	Y	JLD	
Customer Technical Support	Y	DSTOW	

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord	N		
QC Coordinator	Y	JM	
Marketing	Y	SW	
Customer Order Processing	N		

**Reason for Change:**  
Use Magnobond 6398 on crosstube supports. DSI 9425 indicates the change to the customer.

**Documents Affected:**  
Release: D058-676-141/-241 Rev B, DSI 9425 Rev A

PARTS MUST COMPLY ☒ PREVIOUS PARTS SATISFACTORY ☐

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	Y	PH		
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	Y	KJ		08.11.13 <i>[Signature]</i>
9	Update Blue/Pink/DSI Folder and Electronic Files	Y	KJ	Add DSI 9425 Rev A to blue file	08.11.13 <i>[Signature]</i>
10	Update Controlled PDF Files	Y	KJ		08.11.13 <i>[Signature]</i>
11	Update Master Document List (MDL)	Y	PH/RF		08.11.13 <i>[Signature]</i>
12	Update Document Record (DR)	Y	KJ	676 Rev. C	
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	Y	KJ	DSI 9425-0117	
16	Update / Verify ARC Database	Y	KJ	D058-676-101/-201 now at CHG 002, DSI at CHG 001	08.11.13 <i>[Signature]</i>
17	Create / Update Change Record Form	Y	KJ	See above	08.11.13 <i>[Signature]</i>
18	Create / Update PPP's	Y	KJ	AS REQUIRED	N/A <i>[Signature]</i>
19	Update Document Control Database / Laminated Dwgs	Y	KJ	ADR - SENT TO RF/DS FOR SIGNING	08.11.13 <i>[Signature]</i>
20	Update Grey Project Binder	Y	KJ		
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		
22					
23					

### Description / Action:

- Parts have been added/removed see drawings

D058-676-101 (2 in stock, 1 in Prod, B 41398)

D058-676-201 (2 in stock, 2 in Prod, B 41399, 41400)

-101	-201	-101	-201
35530	35533	35532	35535
hangk	hangk	41398	41399
		main	41400

Date:

ECN Verified & Complete:

## L Lacelle

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**From:** Peter Hum [phum@dartaero.com]  
**Sent:** November 21, 2008 3:50 PM  
**To:** 'L Lacelle'; 'Mike Petsche'; 'Kim Johnston'  
**Cc:** 'Alan Stocker'  
**Subject:** RE: ecn's not sure

The ones in Hong Kong are OK as is.....I will update the ECN to indicate this.....Kim please remind me

Yes we can rework the CHG 001's here, remove the abrasion strips and magnobond the supports on

Peter

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**From:** L Lacelle [mailto:llacelle@dartaero.com]  
**Sent:** Friday, November 21, 2008 1:44 PM  
**To:** 'Peter Hum'; 'Mike Petsche'; 'Kim Johnston'  
**Cc:** 'Alan Stocker'  
**Subject:** RE: ecn's not sure

WRONG...

We have one fwd B/N 35532 at chg001, and one aft B/N 35535 at chg001. We also have 1 each in Hong Kong...I can rework the chg001's here...???

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**From:** Peter Hum [mailto:phum@dartaero.com]  
**Sent:** November 20, 2008 1:59 PM  
**To:** 'L Lacelle'; 'Mike Petsche'; 'Kim Johnston'  
**Cc:** 'Alan Stocker'  
**Subject:** RE: ecn's not sure

ECN 08-563,

The last batch of OH-58 crosstubes have already been re-worked I.A.W. the DSI, this was done when the parts were "in progress". These kits need the DSI added to the paperwork. These should be at CHG 002

I don't think we have any in stock to rework anyways

In other words, all the OH-58 crosstubes here should already be at CHG 002 and should have the DSI in the paperwork

Peter

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**From:** L Lacelle [mailto:llacelle@dartaero.com]  
**Sent:** Thursday, November 20, 2008 1:37 PM  
**To:** 'Mike Petsche'; 'Kim Johnston'  
**Cc:** 'Peter Hum'; 'Alan Stocker'  
**Subject:** ecn's not sure

Hi,

24/11/2008



Date: Monday, 24/11/2008 9:59:58 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CC-DAR01 Dart Aerospace Ltd.	<b>Drawing Name</b> :	D058-676-101
<b>Job Number</b> :	43714		
<b>Estimate Number</b> :	10804		
<b>P.O. Number</b> :		<b>Part Number</b> :	D058676101
<b>This Issue</b> :	24/11/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	ECN08-563
<b>First Issue</b> :	24/11/2008	<b>Project Number</b> :	
<b>Previous Run</b> :	00015	<b>Drawing Revision</b> :	
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :		<b>Due Date</b> :	01/12/2008
<b>Comment</b> :		<b>Qty:</b>	1
		<b>Um:</b>	Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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Comment: CROSSTUBES RESOURCE 1

REMOVE FROM STOCK:

1 X D058-676-101 B35532 CHG001

REMOVE SUPPORTS D2891-1

RE-INSTALL PER ECN 08-563

PER DSI 9425, WITH MAGNABOND

 REMOVE D2856-400-694 AND REPLACE  
 WITH D3595-063-395 B

REFERENCE ONLY

2.0	D058676101	Crosstube Fwd
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 Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Crosstube Fwd

3.0	D3595	Rubber Cushion (per sq ft)
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 Comment: Qty.: 1.0000 sf(s)/Unit Total : 1.0000 sf(s)  
 Rubber Cushion (per sq ft)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

Date: Monday, 24/11/2008 9:59:58 AM  
User: Linda Lacelle

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D058-676-101

Job Number: 43714

Part Number: D058676101

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REPACKAGE USING NEW B/N @ CHG002  
NEW LABELS AND PAPERWORK REQ'D

*Labels checked*  
*08/11/27* *JG*

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

